

VOL- 19-7484



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

Tel (613) 632-5200
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D4636-11

Job Sheet 201740



40

Part No: D4636-11

Job Qty: 1 pcs

Part Name: Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/9/19

Job Tracking No:

Due Date: 10/24/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D SHEET 7 IPP REV:A 12.06.14 NEW ISSUE DD VERF:EC IPP REV:B 12.11.08 AS PER DWG
REV:A DD VERF:JLM IPP REV:C 13.07.17 AS PER DWG REV:C DD VERF:JLM

Ship Via:

Bill of Material

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Time	Workcenter/Supplier		Lead Time	Sign-off
						Workcenter /	Supplier		
100	Waterjet - Flow - 1	30 pcs		10/24/19	0.70	Waterjet - Flow		6/17/19	JRB
120	QC 8	30 pcs		10/24/19	0.00	QC 8 - 12			
						QC 8 - 14			
						QC 8 - 17			
						QC 8 - 20			
						QC 8 - 25			
						QC 8 - 3			
						QC 8 - 32			
						QC 8 - 33			
						QC 8 - 35			
						QC 8 - 39			
						QC 8 - 4			
						QC 8 - 44			
						QC 8 - 45			
						QC 8 - 49			
						QC 8 - 58			
						QC 8 - 8			
						QC 8 - 9			
						QC 8 - 68			
						QC 8 - 67			
						QC 8 - 1 (A)			
						QC 8 - 47			
						QC 8 - 40			
						QC 8 - 52			
						QC 8 - 23			
						QC 8 - 57			
						QC 8 - 76			
						QC 8 - 61			
130	Small Fab - 2 - B4B	30 pcs		10/24/19	0.00	Small Fab - 1 - B4B			
					0.86	Small Fab - 2 - B4B			

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Container No: S223290

Part: D4636-11

Job No: 201740

Serial No/Batch: S223290

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/17/19

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140 QC 5	30 pcs	10/24/19	0.00 0.00	Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
150 Handfinish - 1-1 Chemical-B4B	30 pcs	10/24/19	0.00 0.46	QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	

B4B

OCT 18 2019

B4B

OCT 21 2019

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190 Packaging 3-1 - Stock - B4B	30 pcs	10/24/19	0.00 0.00	QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	

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				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
200 QC 21 - SA	30	10/24/19	0.00 0.00	QC 21 - SA - 21	
	pcs			QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 120 - (QC8- Inspect parts - second check)
 Descriptions: 140 - (QC5- Inspect part completeness to step on W/O)
 150 - (Chemical Conversion Coat per QSI005 4.1)
 160 - (QC7-Inspect Chemical Conversion Coat)
 170 - (Black Sandtex(Ref:4.3.5.7) per QSI005 4.3)
 180 - (QC3- Inspect Part Finish)
 190 - (Identify as per dwg & Stock Location: _____)
 200 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.080	6061-T6 .080 Sheet	1.1280 sf (.0376 ea)	100-Waterjet - Flow - 1	5200297

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M6061T6S.080	1	171	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bracket	0.194Inches + 0.005 - 0.001	0.199 0.193	Diameter	1.196
2	Bracket	0.350Inches ± 0.030	0.380 0.320		1.358
3	Bracket	1.000Inches ± 0.010	1.010 0.990		1.998
4	Bracket	2.000Inches ± 0.010	2.010 1.990		2.001
5	Bracket	2.710Inches ± 0.030	2.740 2.680		2.712
6	Bracket	1.640Inches ± 0.030	1.670 1.610		1.635
7	Bracket	0.140 Inches ± 0.005 1.145	0.150 0.140		1.147
8	Bracket	0.080Inches ± 0.010	0.090 0.070		1.080

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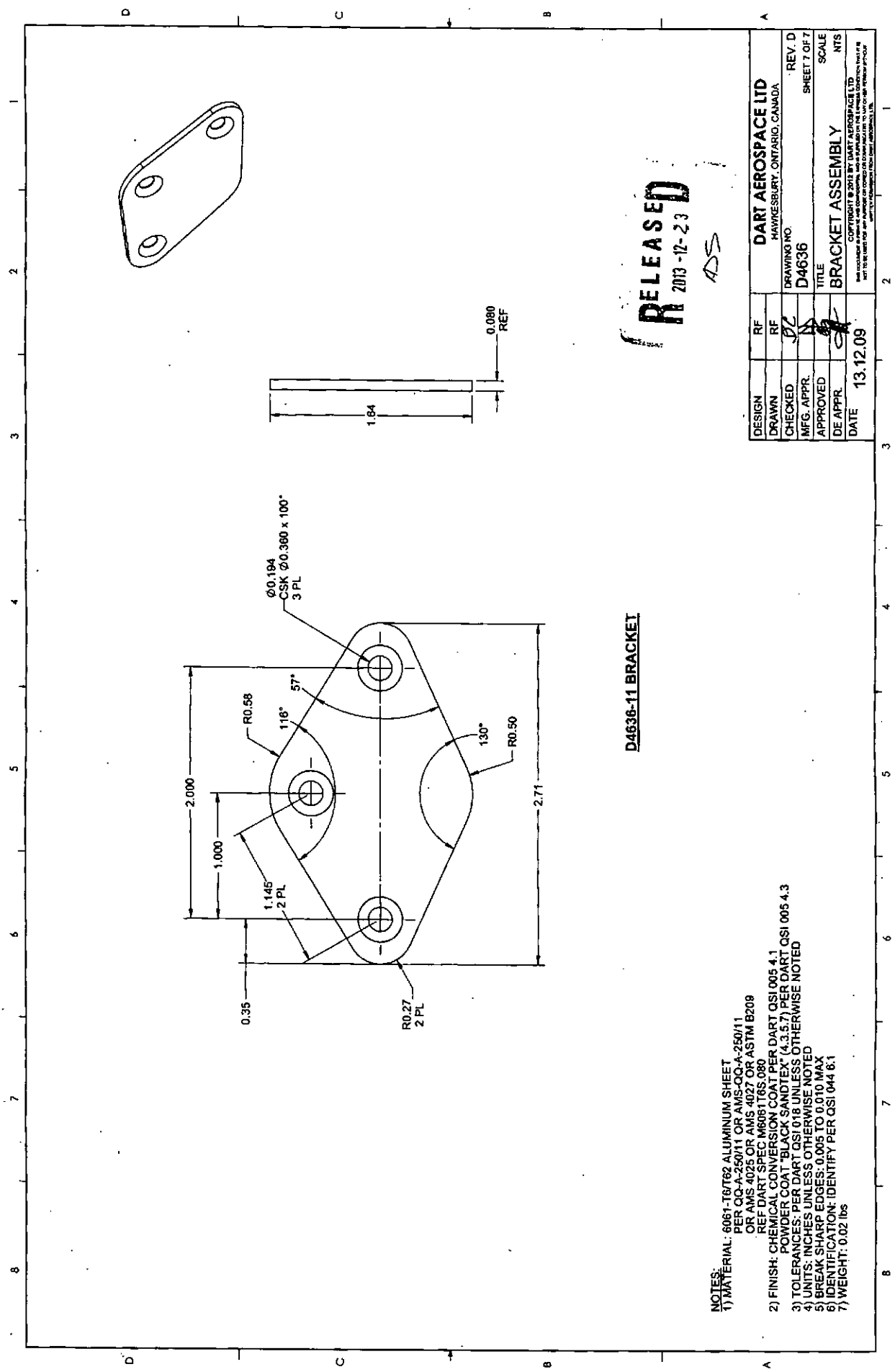
Entered: JK Date: Oct 22/19
 NCR No. 19-7484

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE



Route update only ☐

Job: <u>201740</u> Part No. <u>D4636-11</u>		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Machining ☐ Small Fab ☒ Prod. Eng. Coord. ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	
Date: <u>OCT 21 2019</u>	Sequence #: <u>180-QC3</u>	QTY Affected: <u>40/40</u>		MRB (Q51042) <u>19-10-21</u>	
Description Work Order Deviation		Disposition			
- DRAWING D4636 REV. D, P7/7 CALLS FOR CSK Ø0360" X 0.100, 3 PL. PART IS NOT COUNTER SUNK. - PARTS ARE POWDER COATED.		- REMOVE POWDER COAT. - COUNTER SINK PARTS. <u>PD</u> - ALODINE PARTS - POWDER COAT PARTS - ADD LINE IN SEQUENCE TO INCLUDE COUNTER SINK. after talking with production we decided to scrap all part and make another w/o			
Root Cause Operator ☒ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☒ Fit/Function ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details:			
		Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			
		Completed By <u>Lead hand / Supervisor</u> QC / QA Coordinator <u>19-10-21</u>			



D4636-11 BRACKET

- NOTES:
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET
PER QQ-A-250/11 OR AMS-CQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.080
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 0.02 lbs

RELEASED
R 2013-12-23
ADS

DESIGN	RF	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	RF	DRAWING NO.
MFG. APPR.	RF	D4636
APPROVED	RF	TITLE
DE APPR.	RF	BRACKET ASSEMBLY
DATE	13.12.09	SCALE
		NTS

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